

Work Order ID 136473

Tuesday, September 29, 2015 7:12:24 AM

136473

Page 1

Item ID: K591-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Step Instln
 Start Date: 9/17/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 9/17/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: SEP 29 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9525	A								
104	Pick Kit	0.00							SEP 29 2015 MCS (S)
104									
Packaging	Memo	0.00							
Packaging									
105	QC4- 100% Inspect kits for completeness	0.00							
105									
QC	Memo	0.00							25
Quality Control									15-0930
110	Identify as per dwg & Stock Location	0.00							
110									
Packaging	Memo	0.00							DAS 02 9-89
Packaging	***CHG005***								SEP 30 2015

Handwritten notes:
 PKB
 PPP
 136783 x 4
 136870 x 1

Handwritten stamp:
 DAS 27 9-89

Handwritten stamp:
 SEP 29 2015

Handwritten stamp:
 (S)

Work Order ID 136473***136473***

Page 2

Item ID: K591-113

Accept

N1900040100Setup Start ***NS1***

Revision ID:

Item Name: Short Step Instln

Stop ***NS2***

Start Date: 9/17/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 9/17/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

SEP 30 2015

 20150930

Picklist Print

Tuesday, September 29, 2015 7:12:29 AM

Page 1

Work Order ID: 136473

136473

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 9/17/2015

Required Date: 9/17/2015

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP: C04.11.09ReformatKJ/JLM
as per revG DD 10.04.20 verified by:EC
586 10.06.18 DD verf:EC

IPP Rev:D
IPP Rev:E as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 *D2171* Clamp		Manufactured	No			104	Each	24.0000	2	10		DAS 27 9-89	DAS 9-89
** <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST542				24		10			
				132796				15					
				136282				9					
D2274 *D2274* Radius Block		Manufactured	No			104	Each	100.0000	4	20		DAS 27 9-89	DAS 9-89
** <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				FG				12					
				86855				12					
				ST006				88					
				134217				88		20			
D2182B *D2182B* Rubber Cushion - Black (\$Per Foot)		Manufactured	No			104	f	636.1768	0.5833	2.9165		DAS 27 9-89	DAS 9-89
** <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST411				636.1768		2.9165			
				130427				286.1768					
				135093				350					

2x 3.5" per kit

SEP 28 2015 DAS 6 9-89

Picklist Print

Tuesday, September 29, 2015 7:12:29 AM

Page 2

Work Order ID: 136473

136473

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 9/17/2015

Required Date: 9/17/2015

Start Qty: 5.00

Required Qty: 5.00

D2362-3 Manufactured No

104 Each 6.0000 1 5

D2362-3

Step Support Bracket

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST537

6

133861

2

135870

4

D3595-200-300 Manufactured No

104 Each 34.0000 1 5

D3595-200-300

Rubber Cushion 2.00" wide x 3.00" Long

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

84209

5

ST419

29

130665

29

AN3-37A Purchased No

104 Each 38.0000 2 10

AN3-37A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

ST347

28

m130466

3

m133077

25

AN4-21A Purchased No

104 Each 82.0000 4 20

AN4-21A

Bolt

DAS
02
9-89

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST342

82

m132716

82

SEP 28 2015

Picklist Print

Tuesday, September 29, 2015 7:12:29 AM

Page 3

Work Order ID: 136473

136473

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 9/17/2015

Required Date: 9/17/2015

Start Qty: 5.00

Required Qty: 5.00

AN4-22A

Purchased

No

104

Each

172.0000

1

5

AN4-22A

Bolt

DAS
02
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

50

116419

50

ST342

122

123348

100

m128403

22

NAS1149D0363J

Purchased

No

104

Each

1,223.000

4

20

NAS1149D0363.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

246

m130799

246

GA

248

m130799

248

ST269

729

m126319

7

m131618

1

m132317

10

m132677

50

m133031

661

DAS
02
9-89

SEP 28 2015

Picklist Print

Tuesday, September 29, 2015 7:12:29 AM

Page 4

Work Order ID: 136473

136473

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 9/17/2015

Required Date: 9/17/2015

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

104

Each

2,511.000

6

30

NAS1149D0463J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

1470

M129682

86

M130799

371

M132317

125

M132677

888

**

DAS
27
9-89

DAS
0
9-89

MS21042L3

Purchased

No

104

Each

935.0000

2

10

MS21042L3

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

334

M130922

334

GA

177

M131317

177

ST305

424

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

17

M133134

325

**

DAS
27
9-89

SEP 28 2015

DAS
0
9-89

Picklist Print

Tuesday, September 29, 2015 7:12:29 AM

Work Order ID: 136473

136473

Parent Item: K591-113

K591-113

Parent Item Name: Short Step Instln

Start Date: 9/17/2015

Required Date: 9/17/2015

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

104

Each

1,531.000

5

25

MS21042L4

DAS
27
9-89

Locknut

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1247

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1067

SEP 28 2015

DAS
0
9-89

25

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 Heli-Access-Step™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

136473 MS
15-09-04

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

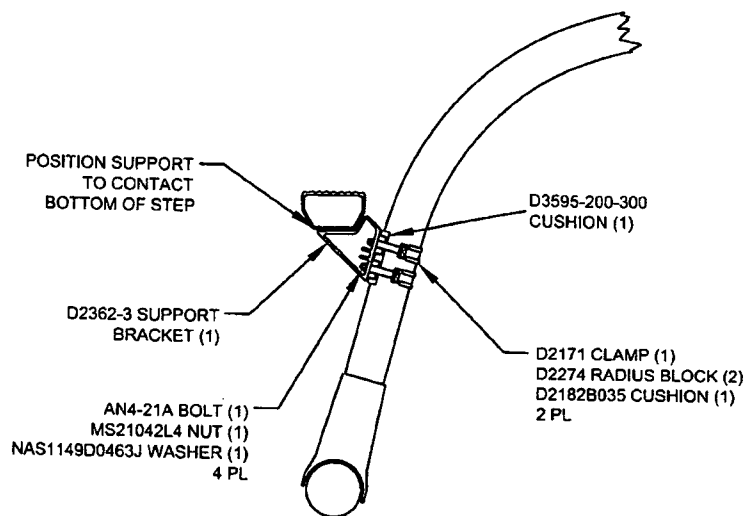
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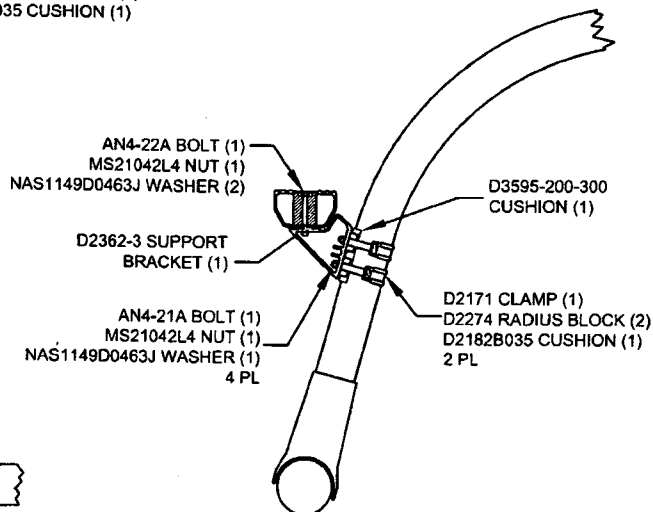
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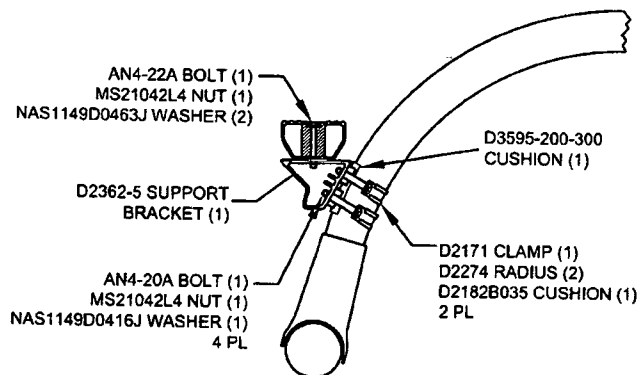
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MFG. APPR.	N/A	DSI 9525	SHEET 2 OF 4
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SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591

FIGURE 9: Crosstube Attachment
REF D350-591

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DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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ISSUE NO.: 11

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 3 OF 4
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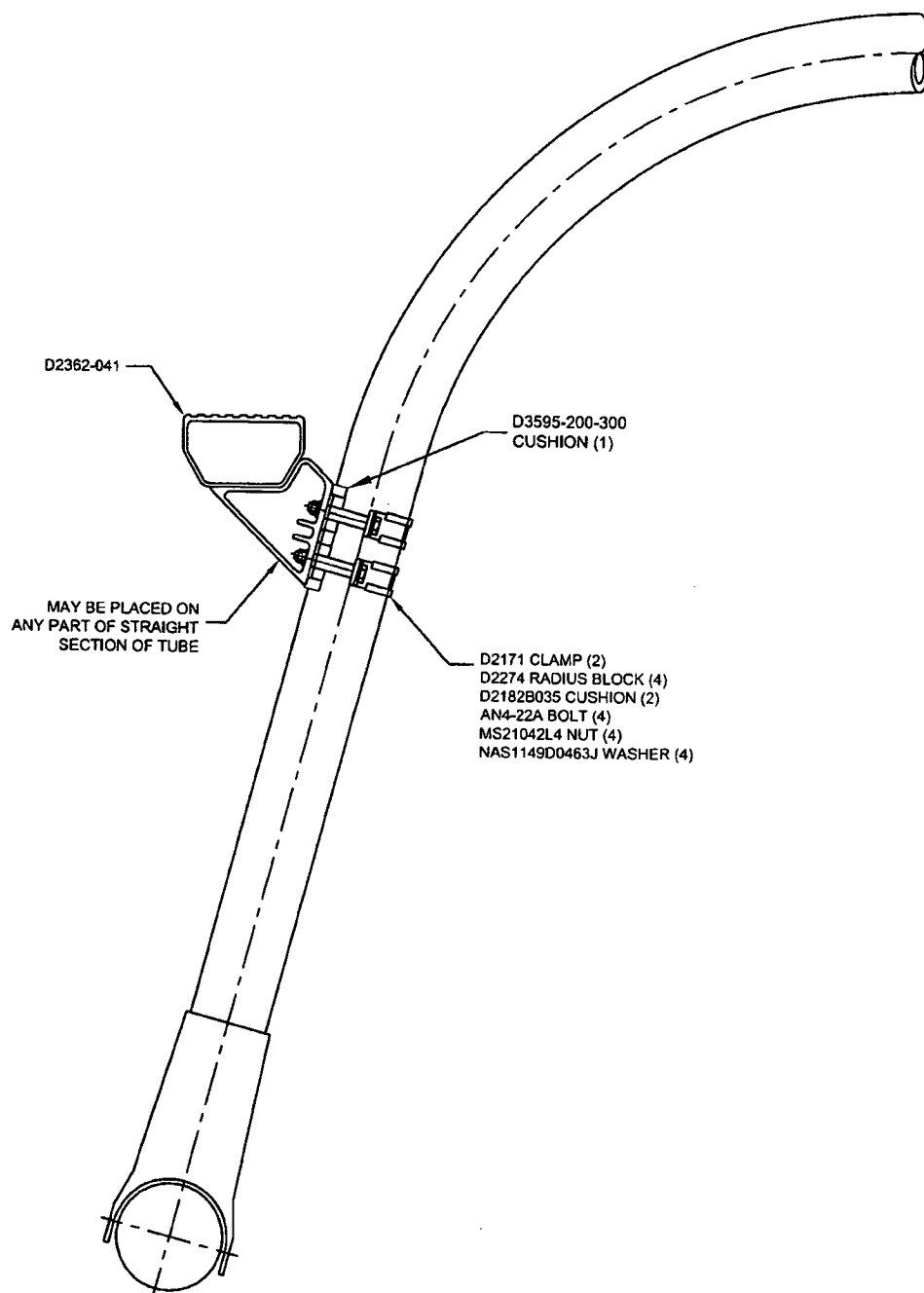


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.06.08
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ISSUE NO.: 11

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 4 OF 4
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REFERENCE ONLY

DAS
02
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DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 *Heli-Access-Step™* (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step - High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step - High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step - Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step - Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-0-01

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BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
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A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
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